

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029881**Date Inspected:** 25-Jul-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

In Process Visual Inspection

ABF-RFI-003402R00, Submittal 2844, CCO289

This QA observed, at random intervals, Dutra welder Dave Selba #29470565 performing Flux Core Arc Welding (FCAW) with .072 diameter E71T-8 electrode and implementing Welding Procedure Specification (WPS) Dutra Knife Plate Revision 0. Welding was performed on Knife Plates to Top Plate.

RN1A Set 1-5 was completed on this date. (A set consists of two Knife Plates.)

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters.

This QA Inspector performed 10% Magnetic Particle (MT) testing along the length of, and the edges of the knife plate on the Top Plate at RN1A 1-5. This QA Inspector performed MT testing utilizing the yoke method in conformance with ASTM E 709 and the standard of acceptance with D1.5 section 6.26.2.1. This QA Inspector noted that no rejectable indications were found at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work at this location appeared to be in general conformance with the contract

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specifications.

This QA observed QC Inspector William Sherwood performing welding parameter checks such as voltage, amps, electrodes and preheats throughout the day. Non-Destructive Testing methods utilized by the QC Inspector was Visual Testing (VT), Magnetic Particle Testing (MPT). The QC Inspector was observed performing inspection per applicable code and or contract criteria. Unless otherwise noted, all work observed on this date appeared to generally comply with the contract documents.

Summary of Conversations:

Conversations on this date were relevant to work performed.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027 , who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
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Reviewed By:	Reyes,Danny	QA Reviewer
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